

FF. Rucher

Work Order ID 73826



Page 1

Friday, September 16, 2011 11:36:16 AM

Item ID:	D2647	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Cap					
Start Date:	9/16/2011	Start Qty:	200.00			
Required Date:	10/14/2011	Req'd Qty:	200.00			
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2647	Rev F								

100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D2647								
6661 - 082	Dwg Rev: F								
	Prog Rev: F								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control									

B11-9-26

(200)

B11-9-26

counts

(x200)

08/16/11

8 w/08/17

Work Order ID 73826

Friday, September 16, 2011 11:36:16 AM

Page 2

Item ID: D2647

Accept

Revision ID:

Item Name: Cap

Start Date: 9/16/2011 Start Qty: 200.00

Required Date: 10/14/2011 Req'd Qty: 200.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Small Fab

Small Fab

Small Fab

Memo
Debur

0.00

0.00

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

150



Packaging

Packaging

Identify as per dwg & Stock Location *SLG*

Memo

STOCK IN SKIDTUBE CELL

0.00

0.00

gp 11-09-28

Work Order ID 73826

Friday, September 16, 2011 11:36:16 AM



Page 3

Item ID: D2647

Accept



Setup Start



Revision ID:

Stop



Item Name: Cap

Start Date: 9/16/2011 Start Qty: 200.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 200.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/28

11-09-28
200

Picklist Print

Friday, September 16, 2011 11:36:14 AM

Page 1

Work Order ID: 73826

Parent Item: D2647

Parent Item Name: Cap



Start Date: 9/16/2011

Required Date: 10/14/2011

Start Qty: 200.00

Required Qty: 200.00

Comments: IPP Rev:D□99.01.25□Re-format□DM
IPP: E 06.11.15 waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased	No			100	sf	116.3000	0.1597	33.62105			



6061-T6 .080 Sheet



811-9-26

Location

Loc Qty

Loc Code

MAT021

116.3

116268

9.5

117285

106.8

119.028

119.028

(200)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 73826
Description: Cap		Part Number: D2647
Inspection Dwg: D2647	Rev: F	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	.100	✓		✓ B02	
Ø0.129	+0.005/-0.001	.130	✓		✓	
0.420	+/-0.010	.425	✓		✓	
0.810	+/-0.010	.811	✓		✓	
0.350	+/-0.010	.350	✓		✓	
0.720	+/-0.010	.720	✓		✓	
0.370	+/-0.010	.370	✓		✓	
2.90	+/-0.030	2.907	✓		✓	
6.85	+/-0.030	6.851	✓		✓	

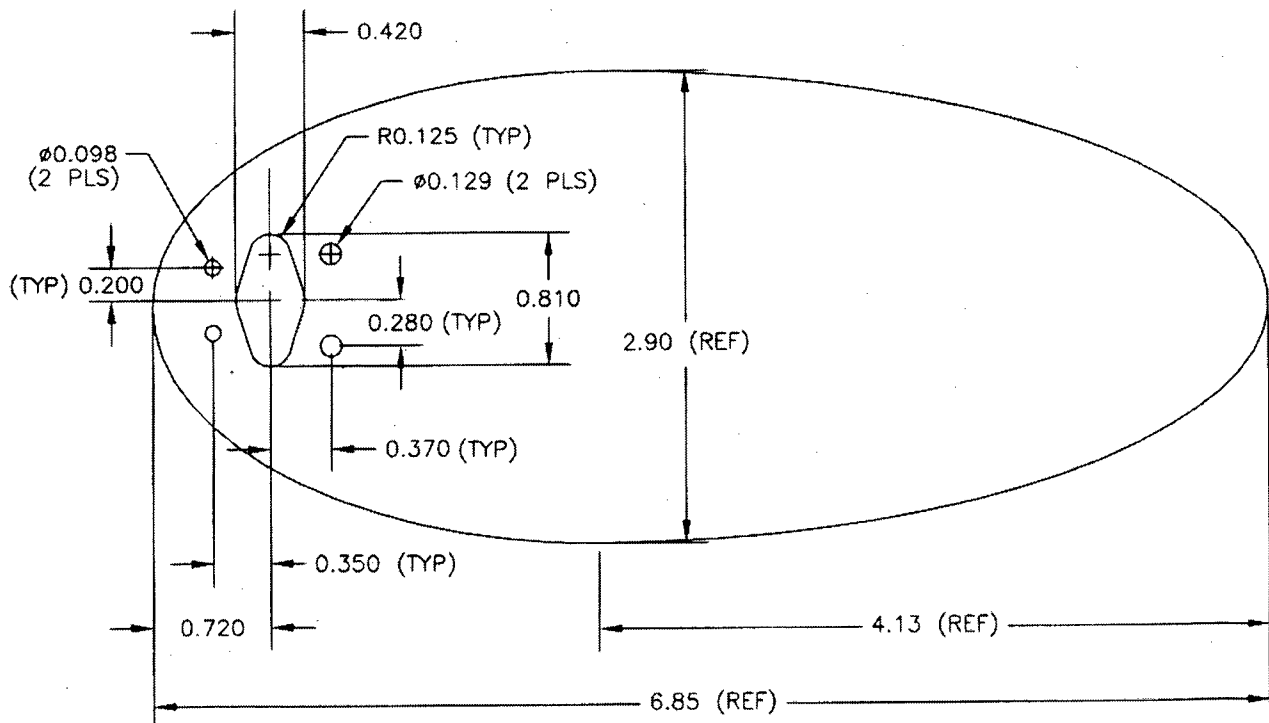
Measured by: B	Audited by: S	Prototype Approval: N/A
Date: 11-9-26	Date: 11/09/27	Date: N/A

Rev	Date	Change	Revised by	Approved
A	07.11.26	New Issue	KJ/EC/DD	
B	09.03.10	0.370 dimension removed	KJ/DD	



DESIGN #	DRAWN BY RT	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED #	APPROVED #	DRAWING NO. D2647	REV. F SHEET 1 OF 1
DATE 00.05.26		TITLE CAP	SCALE NTS
A	97.03.25	NEW ISSUE	
B	97.06.27	CHANGED SHAPE	
C	97.09.15	REMOVE FRONT PLATE	
D	97.11.06	ADD RIVET HOLES	
E	98.01.15	ADD 5052 MATERIAL (TSR A245)	
F	00.05.26	MAKE FROM D2794	

RELEASED
00.05.26



THIS PART CAN BE MADE FROM D2794

MATERIAL: 6061-T6 (QQ-A-250/11) OR
5052-H32 (QQ-A-250/8) 0.080 THICK
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Copyright © 1997 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.